

Work Order ID 69615

Thursday, May 12, 2011 3:35:49 PM

Page 1

Item ID: D3560-041

Accept

Revision ID:

Item Name: Arm Weldment

Start Date: 5/12/2011

Start Qty: 600

Required Date: 5/24/2011

Req'd Qty: 600

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 16.750" long

0.00

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Mill as per Folio FA693 Rev: 00 & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

0.00

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69615

Thursday, May 12, 2011 3:35:49 PM



Page 2

Item ID: D3560-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

ent 11/06/02

6 0

140



Large Fab

Large Fab

Large Fab

Memo

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

0.00

0.00

11.06.06

6 0

P10 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 8560-01 PAR #: _____ Fault Category: Large FAB. / Process NCR: Yes No DQA: 11 Date: 11.06.09
11-653 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 11 Date: 11/06/10

NCR: <u>369615</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/6/08</u>	<u>#140</u>	<u>Found at welding inspection</u> <u>a crack in the D3592-1 R/C. Process</u>	<u>CP</u> <u>11.06.08</u> <u>OSUN</u>	<u>→ cut out crack and</u> <u>fill in with weld</u> <u>As per DSZ 004</u> <u>A/R M114703 qty x1</u>	<u>11.06.08</u>	<u>8</u> <u>11.06.08</u>	<u>CP</u> <u>11.06.08</u> <u>OSUN</u>	<u>8</u> <u>11.06.08</u>
				<u>REF W/O 44472</u>				

NOTE: Date & initial all entries

Work Order ID 69615

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Page 3

Item ID: D3560-041

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Setup Start



Revision ID:

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Item Name: Arm Weldment

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8 W/O 6/6/08

6

-841

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Memo

6 0 841 11/06/08

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

6X 0 M 11/06/08

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Page 4

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Item Name: Arm Weldment

Start Date: 5/12/2011 Start Qty: 6.00

Required Date: 5/24/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 BL 11-6-81

190

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

2/3 11/06/09 6

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublog

6 041

W/O:		WORK ORDER CHANGES					
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Page 5

Item ID: D3560-041

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Revision ID:

Stop

Item Name: Arm Weldment

Start Date: 5/12/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

*11-06-09**6**φ*

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/9**MF**11-06-09*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:35:56 PM

Page 1

Work Order ID: 69615

Parent Item: D3560-041

Parent Item Name: Arm Weldment



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808



Bushing

Manufactured

No

100

Each

11.0000

1

6

Location

Loc Qty

Loc Code

GA

11

32896

2

46738

9

M6061T6B0.500X05.00

0



6061-T6 Bar .500 x 5.00

Purchased

No

140

f

16.0000

1.395

8.810526

Location

Loc Qty

Loc Code

MAT004

16

112154

16

D3592-1



Plate

Manufactured

No

190

Each

75.0000

1

6

Location

Loc Qty

Loc Code

WA002

75

47015

27

48517

48

8/5/06/09
B69605 (6x)

8.37 on 11/05/31

11-06-06

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	49615
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø0.5065	✓		Mic	GA-03
Ø0.196	+0.005/-0.001	Ø0.198	✓		Vern	GA-01
Ø1.000	+0.010/-0.001	Ø1.004	✓		"	"
0.500	+/-0.010	0.494	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.275	+/-0.010	0.275	✓		"	"
0.188	+/-0.010	0.187	✓		"	"
2.000	+/-0.010	1.999	✓		"	"
1.700	+/-0.010	1.699	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	.385 x 100°	✓		"	"
0.250 Deep	+/-0.010	0.247	✓		"	"

Measured by:	BA	Audited by:	CMR	Prototype Approval:	N/A
Date:	11/05/31	Date:	11/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

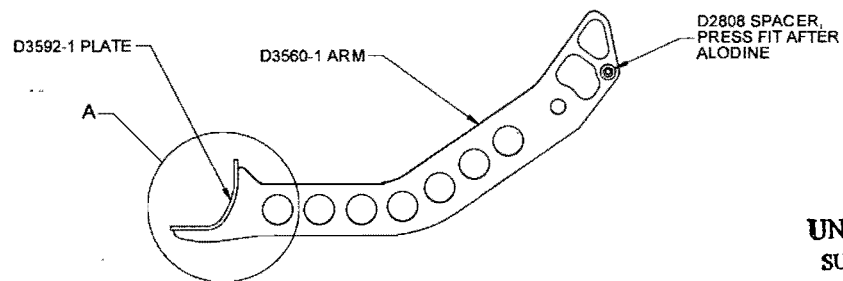
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

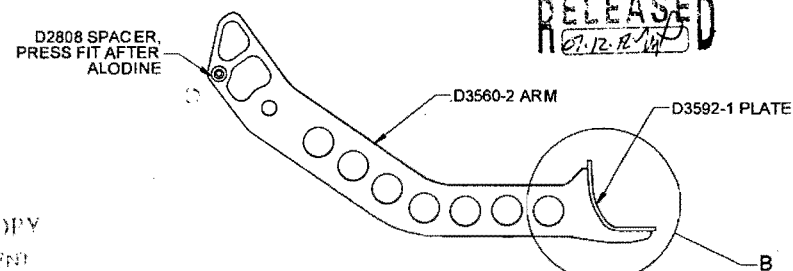
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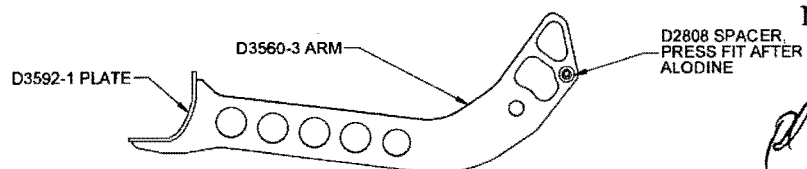
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07.12.12



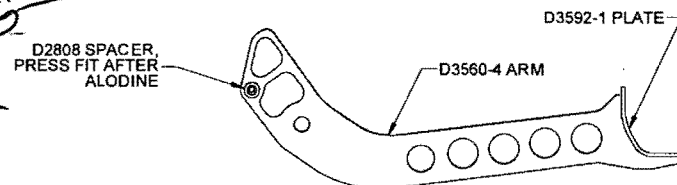
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT



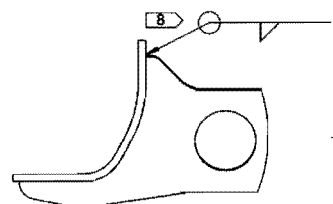
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69615

11-05-12



**DETAIL A
SCALE 1:2**

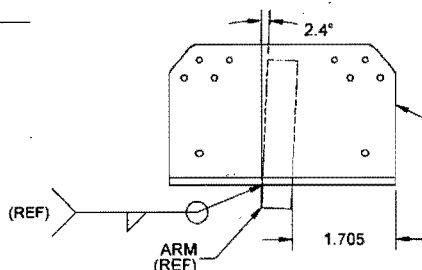
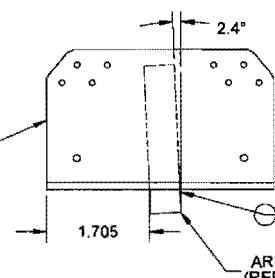
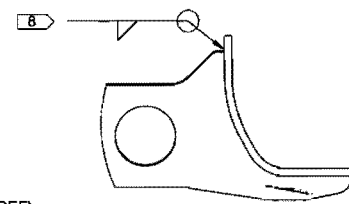


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3560
TITLE
ARM WELDMENT
SCALE
1:4

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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

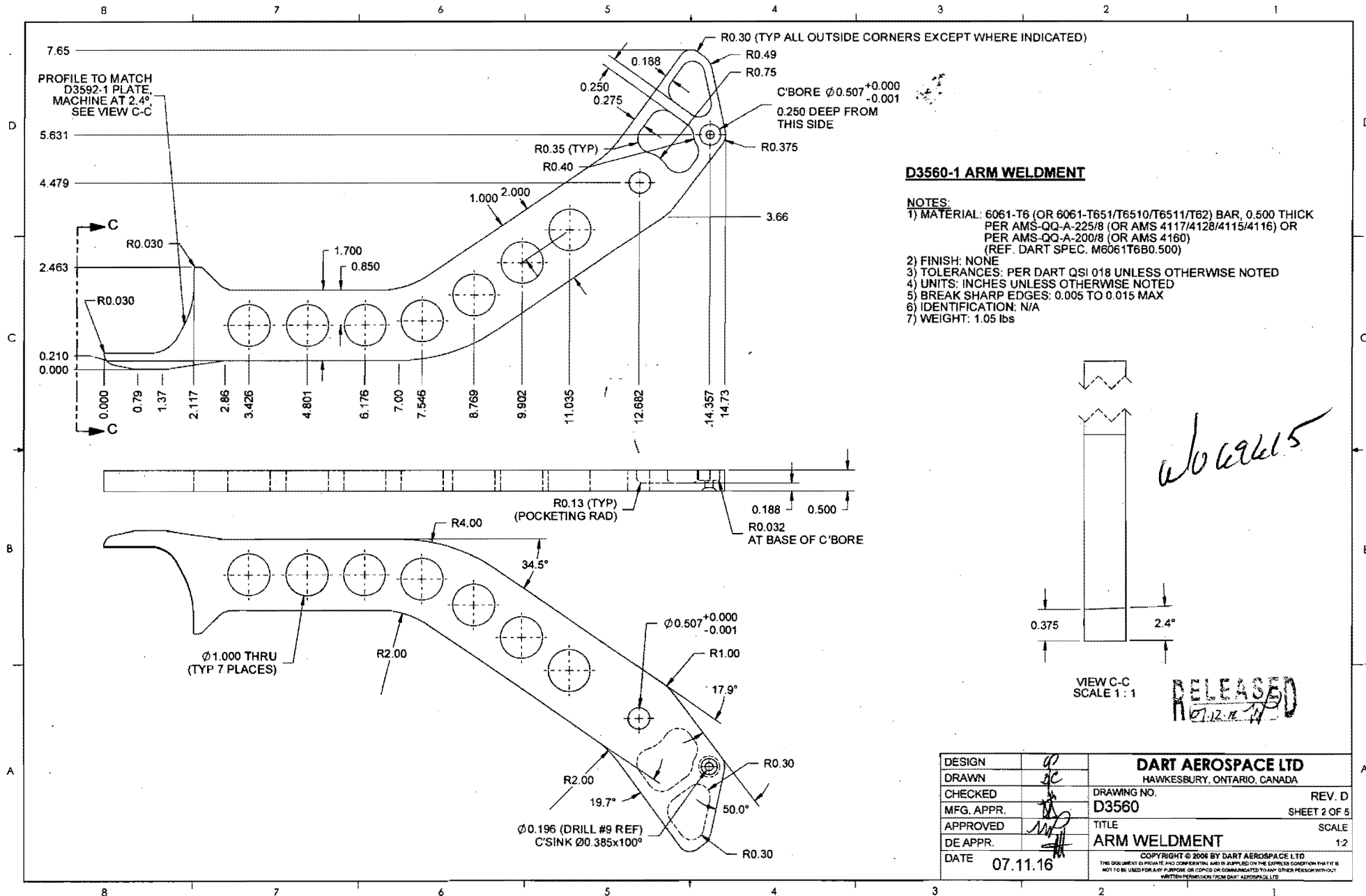
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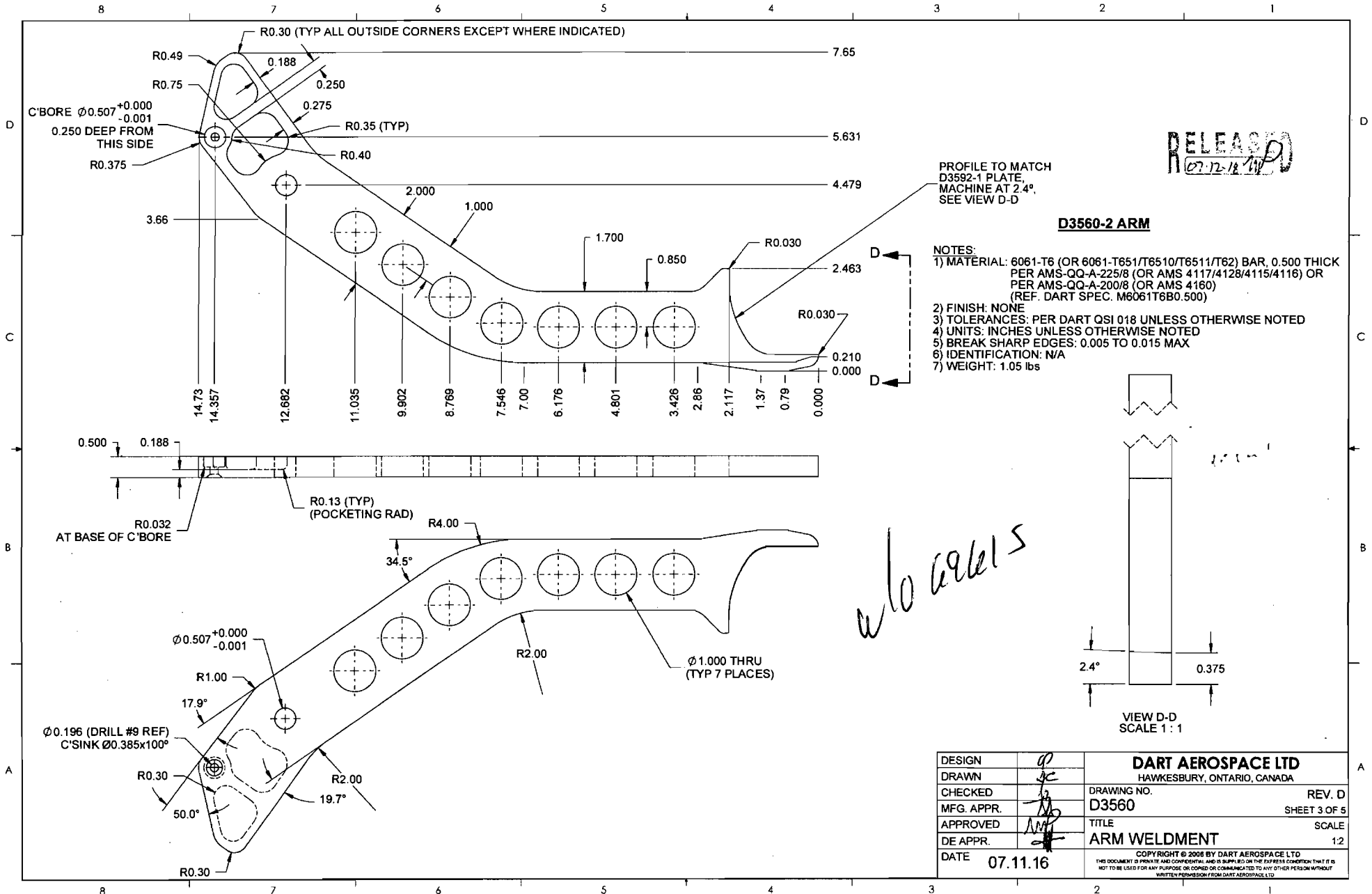
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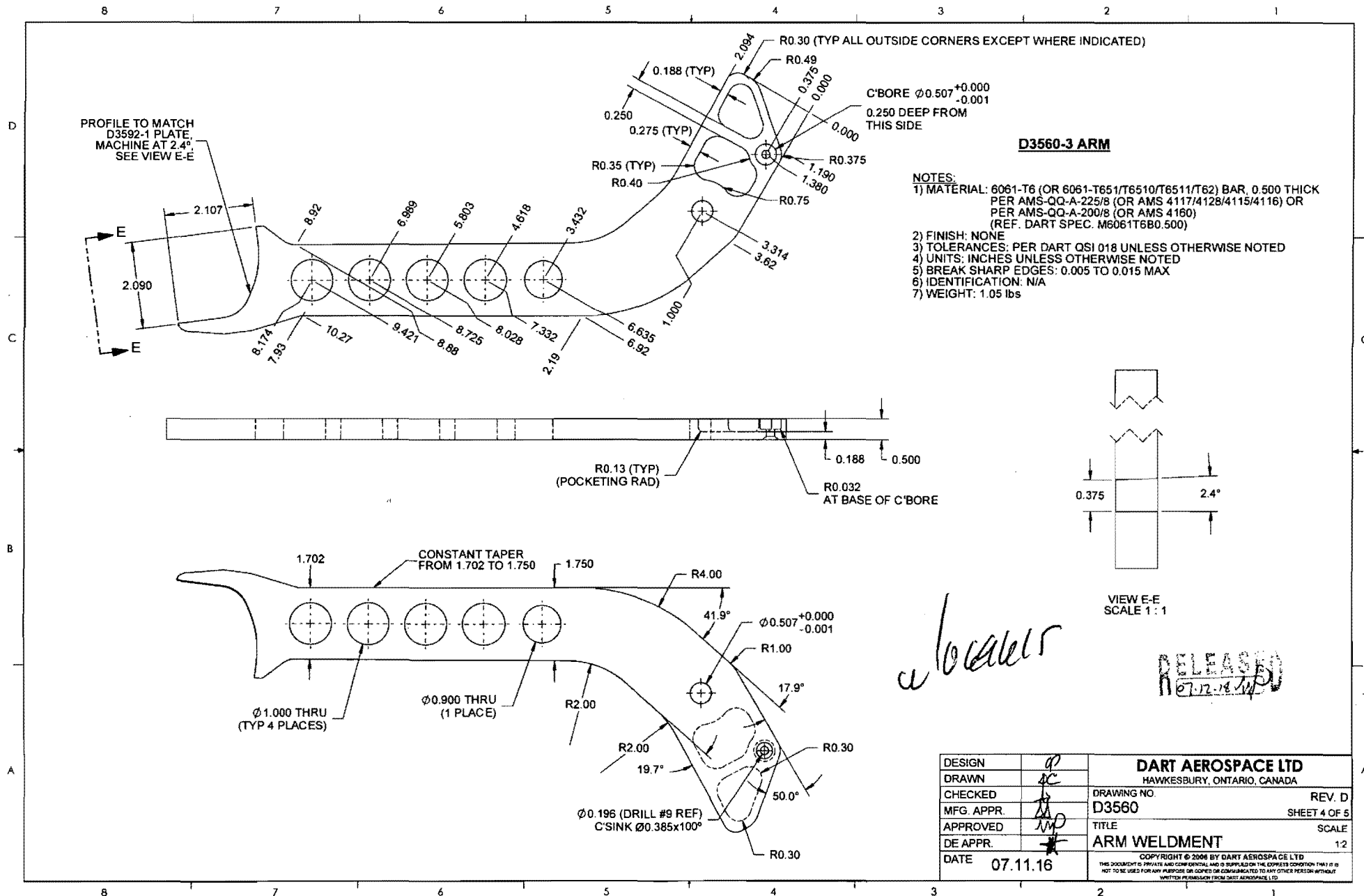
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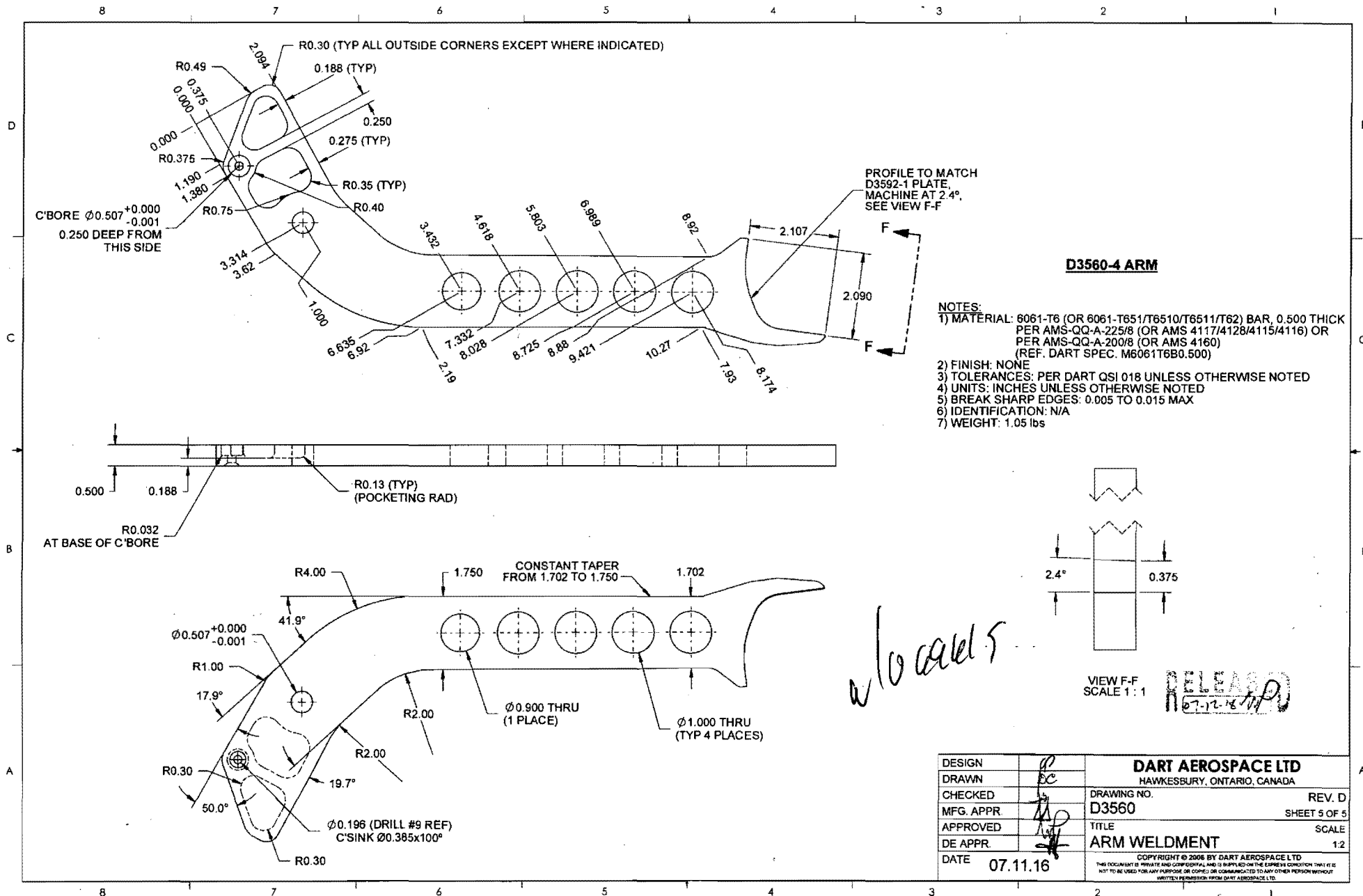
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